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D3914-041
Job Sheet 166662-A



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/13/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	12-12-09
100	Large Fab	1 pcs	10/30/17	0.00	6.67	Large Fab 1	17-12-05
110	QC	1 pcs	10/30/17	0.00	0.00	QC9	17-12-06
120	QC	1 pcs	10/30/17	0.00	0.00	QC5	17-12-09
130	Powdercoat	1 pcs	10/30/17	0.00	0.40	Powdercoat4	17-12-11
135	QC	1 pcs	10/30/17	0.00	0.00	QC3	17-12-11
140	HandFinish	1 pcs	10/31/17	0.00	0.80	HandFinish3	17-12-11
150	QC	1 pcs	10/31/17	0.00	0.00	QC3	38
160	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	9-89
170	QC21-SA	1 Ea	10/31/17	0.00	0.00	QC21	DEC 14 2017

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 135418

START: 10:30 O.V.T: 320

FINISH: 11:00.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5005842	2	28	0	0
	D3914-1 011790	2	4	0	0
	D3914-7 010143	2	2	0	0
	D4016-3	3	22	0	0
	D4018-5 011651	9	18	0	0
	D4020-5 8013374	1	1	0	0
	D4021-3 8017087	1	8	0	0
	D4025-0435 010320	2	2	0	0
	D2728-3	1	0	0	0
140-HandFinish					

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No: _____ NCR No: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date: _____

Ster: _____

QTV Effective: _____

MRB (QSI042) Approval

Description Work C

DART
AEROSPACE
S017794



Long Basket Lid Assembly (350)

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www.dartaerospace.com

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

PART NO: D3914-041
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/06/17**Job No: 166662-A****Root Cause**

Environment ☐	No Re-verification ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Picked ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Crushing ☐	Countersink ☐	Off-set ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐				Drawing ☐
Tribal Knowledge ☐	Rushing ☐				Finish ☐
LOA ☐	Product Improvement ☐				Misread ☐
Substation ☐	Process Improvement ☐				Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐				
OTHER: _____					